

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006319**Date Inspected:** 15-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

BAY#5

SAW welding of weld joint CB-202-B-006-001,and the Welder is identified as 250341.ZPMC QC is identified as Li Yang .The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S2.

Magnetic Particle Testing :

This QA inspector performed MT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) are identified as OBG Deck Panels.

The weld designations reviewed are as follows:

1. DP-391-001
2. DP-120-001
3. DP-389-001

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- 4. DP-200-001
- 5. DP-254-001

Green Tagging for Deck Panels:

This QA inspector performed Final VT for Green Tagging which one previously tested and accepted by ZPMC Quality Control personnel, ABF QA personnel and Caltrans QA personnel . The member(s) are identified as OBG Deck Panels.

The Panels are as follows:

- 1. DP-173-001 Green Tag No:6716
- 2. DP-200-001 Green Tag No:6717
- 3. DP-148-001 Green Tag No:6718
- 4. DP-391-001 Green Tag No:6719

BAY# 3

Ultrasonic Testing :

This QA inspector performed UT of approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member(s) are identified as OBG Floor Beam.

The weld designations reviewed are as follows:

- 1. FB012-022-045
- 2. FB012-023-045
- 3. SSD19-PP072-136-137
- 4. SSD12-PP076-134-135
- 5. FB003-131-008,020,032
- 6. FB003-155-008,020,032

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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